












Date: Thursday, 04/12/2008 9:47:39 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOUNTING PLATE
<b>Job Number</b> : 43906	
<b>Estimate Number</b> : 12408	
<b>P.O. Number</b> :	<b>Part Number</b> : D34992
<b>This Issue</b> : 04/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3499 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 40722	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 12/01/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08-12-04</u>	
<b>Comment</b> : Est Rev: A New Issue 06-05-05 JLM Est Rev: B As per Rev B 06-08-31 JLM	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0	M6061T6S125 6061-T6 .125 Sheet
	
	
<b>Comment:</b> Qty.: 1.1214 sf(s)/Unit Total: 4.4856 sf(s) 6061-T6 .125 Sheet (M6061T6S0125) Batch: <u>109058</u> <u>HB 8-12-11</u>	
2.0	WATER JET FLOW WATER JET
	
	
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3499 Dwg Rev: <u>B</u> <u>HB 8-12-11</u> Prog Rev: <u>B</u> <u>(5)</u> 2-Deburr if necessary <u>HB 8-12-11</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-12-11</u>	
4.0	QC8 SECOND CHECK
	
	
<b>Comment:</b> SECOND CHECK <u>508/12/11</u> <u>(X5)</u>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
	
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 <u>Done at step 222</u> Deburr if necessary. <u>86/12/11</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 04/12/2008 9:47:40 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 43906

Part Number: D34992

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3499

SB 08/12/18 (5)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18 PS

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 08/12/19 (5)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

~~10:30~~ 11:40  
320 °F  
~~11:00~~ 12:10

M-L 08/12/19

(5X)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS 08/12/22 (X)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

~~PP4342~~ PP43905

SS 08/12/22

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



W 08.12.22

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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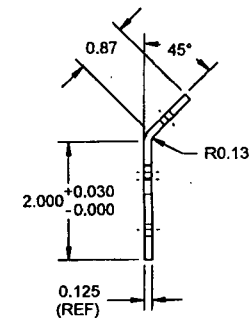
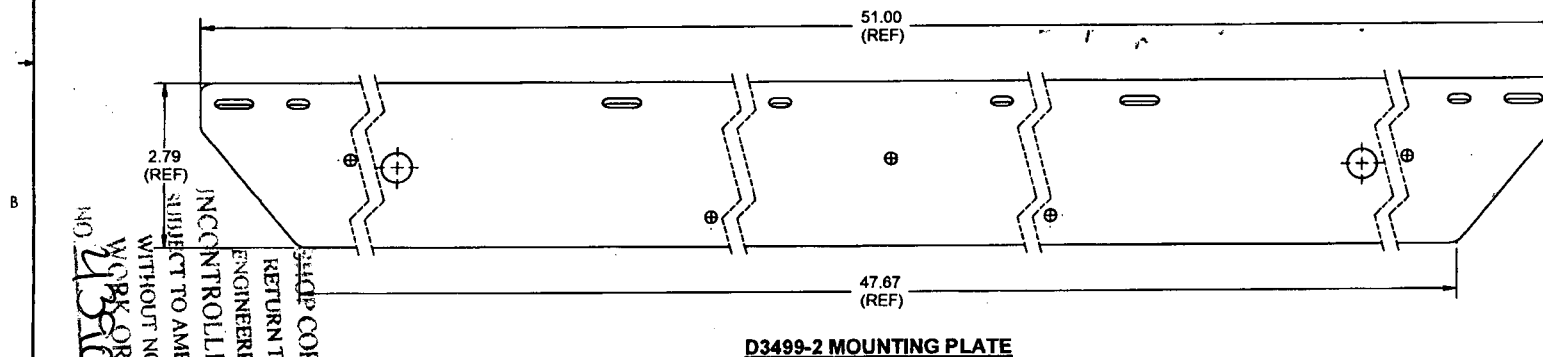
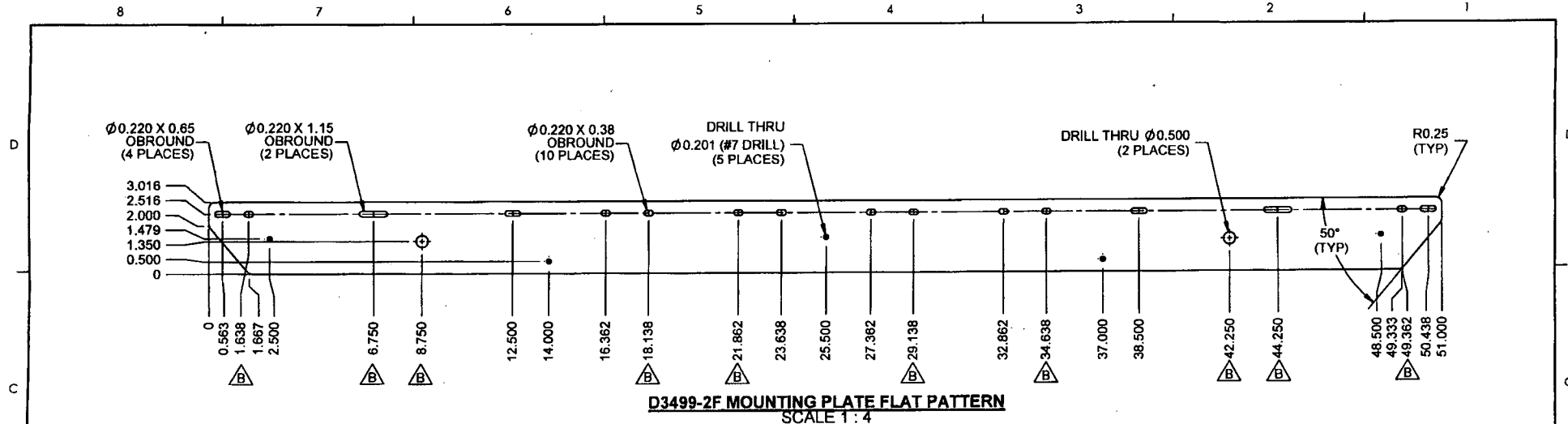
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# **NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M8061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**  
05 10 05

DESIGN B	DRAWN BY B	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:2

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